

628033

Dart Aerospace Ltd.

Date Wednesday, 15/08/2007 3:50:04 PM  
User Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT-STEP ASSEMBLY LH (206/407)  
 Job Number : 33923A  
 Estimate Number : 11664  
 P.C. Number : N/A Part Number : D2842041  
 This Issue : 15/08/2007 S.O. No. : N/A Drawing Number : D2842 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : B  
 Previous Run : 33921A Material : N/A  
 Written By : Due Date : 10/09/2007 Qty: 3 Um: Each  
 Checked & Approved By :  
 Comment : Est Rev: D As Per Ecn 766 06-01-06 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

| Qty | Part #     | Description | Batch   |
|-----|------------|-------------|---------|
| 1   | D2622-120C | Extrusion   | 3 32858 |

Check Material for any Dents or Defects

PE 07-08-24

3

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842

3-Deburr and bevel ends for welding

am 07-08-24

PE 07-09-05

PE 07-09-05

3

3

3

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 2   | D2734       | End Cap     | 330883 |

PE 07-09-05

3

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 15/08/2007 3:50:04 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 33923A

Part Number: D2842041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |        |       |
|-----|--------|-------|
| 4.0 | D34593 | plate |
|-----|--------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3459-3 Lug 333226

*SE 07-09-05 3*

|     |        |       |
|-----|--------|-------|
| 5.0 | D34591 | plate |
|-----|--------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3459-1 Lug 333807

*SE 07-09-05 3*

|     |             |                              |
|-----|-------------|------------------------------|
| 6.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per Dwg D2842

A/R AL Rod Batch: M103794

M104721

2-Grind end cap weld flush A.M

07.09.06

*SE 07-09-05 3*

3

|     |     |                              |
|-----|-----|------------------------------|
| 7.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

*En 07/09/06 (x3 LH)*

|     |     |                           |
|-----|-----|---------------------------|
| 8.0 | QC9 | VISUAL WELDING INSPECTION |
|-----|-----|---------------------------|



Comment: VISUAL WELDING INSPECTION

*07/09/06 (3)*

|     |                 |                            |
|-----|-----------------|----------------------------|
| 9.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M 07-09-06

3

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:50:04 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 33923A

Part Number: D2842041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten:* 07-09-10 3

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: *m103794*

*Handwritten:* 07-09-10 3

2-Grind end cap weld flush.

*Handwritten:* a.m 07.09.10

*Handwritten:* 3

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Handwritten:* 07/09/11 (2)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 07/09/11 (364)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 46

*Handwritten:* m. 07-09-11 (3)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten:* (3)

16.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Insert

Pick:

Qty Part Number

Description Batch

3 NAS1329C3KB130Insert

*Handwritten:* m105385

*Handwritten:* ml 07 09 11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 15/08/2007 3:50:04 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 33923A

Part Number: D2842041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|      |             |       |
|------|-------------|-------|
| 17.0 | MS27039C107 | screw |
|------|-------------|-------|



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 MS27039C1-07

Screw

ml 05426

ml 07 09 11

|      |            |        |
|------|------------|--------|
| 18.0 | NAS1515H3L | WASHER |
|------|------------|--------|



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3 NAS1515H3L

WASHER

ml 04 603

ml 07 09 11

|      |           |        |
|------|-----------|--------|
| 19.0 | AN960C10L | washer |
|------|-----------|--------|



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10L

WASHER

ml 05143

ml 07 09 11

|      |                 |                            |
|------|-----------------|----------------------------|
| 20.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|------|-----------------|----------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

ml 07 09 11 (3)

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: 105386

ml 07 09 11

(3)

|      |     |                              |
|------|-----|------------------------------|
| 21.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

ml 07 12 (3)

|      |             |                       |
|------|-------------|-----------------------|
| 22.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP 33923

CU 1/3/12 (3)

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 33923A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC21

FINAL INSPECTION/W/O RELEASE



③

Comment: FINAL INSPECTION/W/O RELEASE

207/09/19

Job Completion



W 07/09/18

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

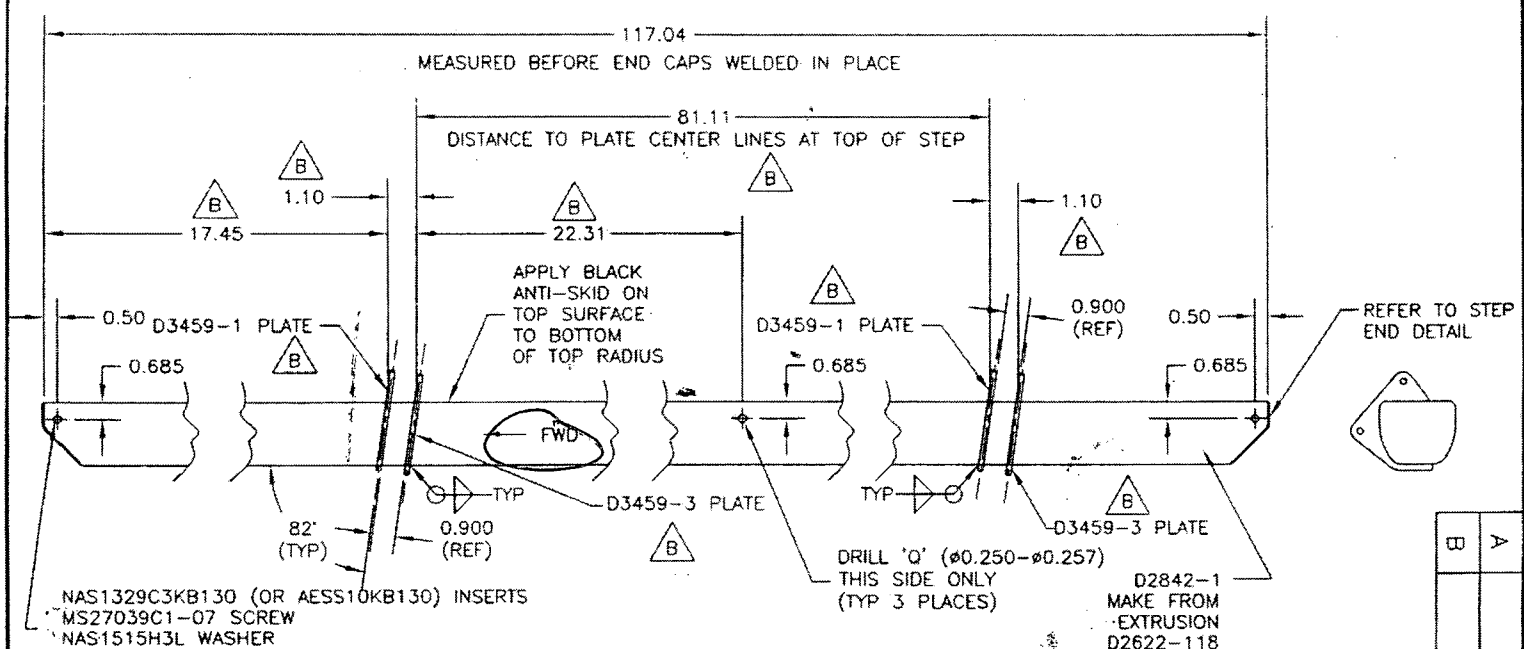
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

106339238

**DART**



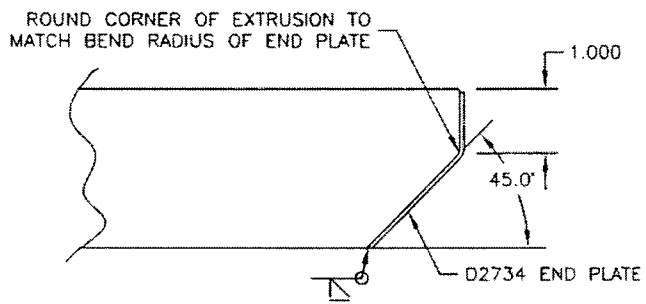
NAS1329C3KB130 (OR AESS10KB130) INSERTS  
 MS27039C1-07 SCREW  
 NAS1515H3L WASHER  
 AN960C10L WASHER  
 (TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)  
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

NOTE: ALL WELDS SHALL  
 BE 100% VISUALLY  
 INSPECTED BY A QUALIFIED  
 INSPECTOR PER DART  
 QSI 004

**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

| QTY<br>-041 | QTY<br>-042 | PART NUMBER                        | DESCRIPTION      |
|-------------|-------------|------------------------------------|------------------|
| X           |             | D2842-041                          | LH STEP ASSEMBLY |
|             | X           | D2842-042                          | RH STEP ASSEMBLY |
| 1           | 1           | D2622-118                          | EXTRUSION        |
| 2           | 2           | D2734                              | END PLATE        |
| 2           | 2           | D3459-1                            | PLATE            |
| 2           | 2           | D3459-3                            | PLATE            |
| 3           | 3           | NAS1329C3KB130<br>(OR AESS10KB130) | INSERT           |
| 3           | 3           | MS27039C1-07                       | SCREW            |
| 3           | 3           | NAS1515H3L                         | WASHER           |
| 3           | 3           | AN960C10L                          | WASHER           |



TYPICAL STEP END DETAIL  
 NOT TO SCALE

**D2842-041/-042 FLOAT STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
 APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
 05/11/14

|                        |                         |  |
|------------------------|-------------------------|--|
| DESIGN<br>KE           | DRAWN BY<br>PH          | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D2842                         |
| DATE<br>05.09.23       |                         | TITLE<br>206L/407 FLOAT STEP ASSEMBLY        |
| A                      | 98.10.13                | NEW ISSUE                                    |
| B                      | 05.09.23                | RE-DESIGN, ADD D3459-1/-3                    |
|                        |                         | SCALE<br>N15                                 |
|                        |                         | REV. B<br>SHEET 1 OF 1                       |

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